

Date: Monday, 19/01/2009 2:06:17 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT
Job Number : 44896	
Estimate Number : 11087	
P.O. Number :	Part Number : D31763
This Issue : 19/01/2009 S.O. No. :	Drawing Number : D3176 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37585	Material :
Written By :	Due Date : 10/02/2009 Qty: 20 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev:B Removed -1 05-11-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R1000	303 Round Bar 1.00
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Comment: Qty.: 0.0525 f(s)/Unit Total : 1.0500 f(s)
 Material: AISI 303 SS 1.00 round bar
 Ref: Dart Spec: M303R1.000)
 Batch: M110379

df
09/01/24

20 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA286 & DWG D3176

2-Deburr

df
09/01/24

20 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

df
09/01/24

20 pcs

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Mill flats as per dwg D3176

2- Deburr

df 09/01/27 20

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Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

28/09/01/27 (20)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28/09/01/28 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 74

9/1/29

30

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



JUD 09/01/29 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

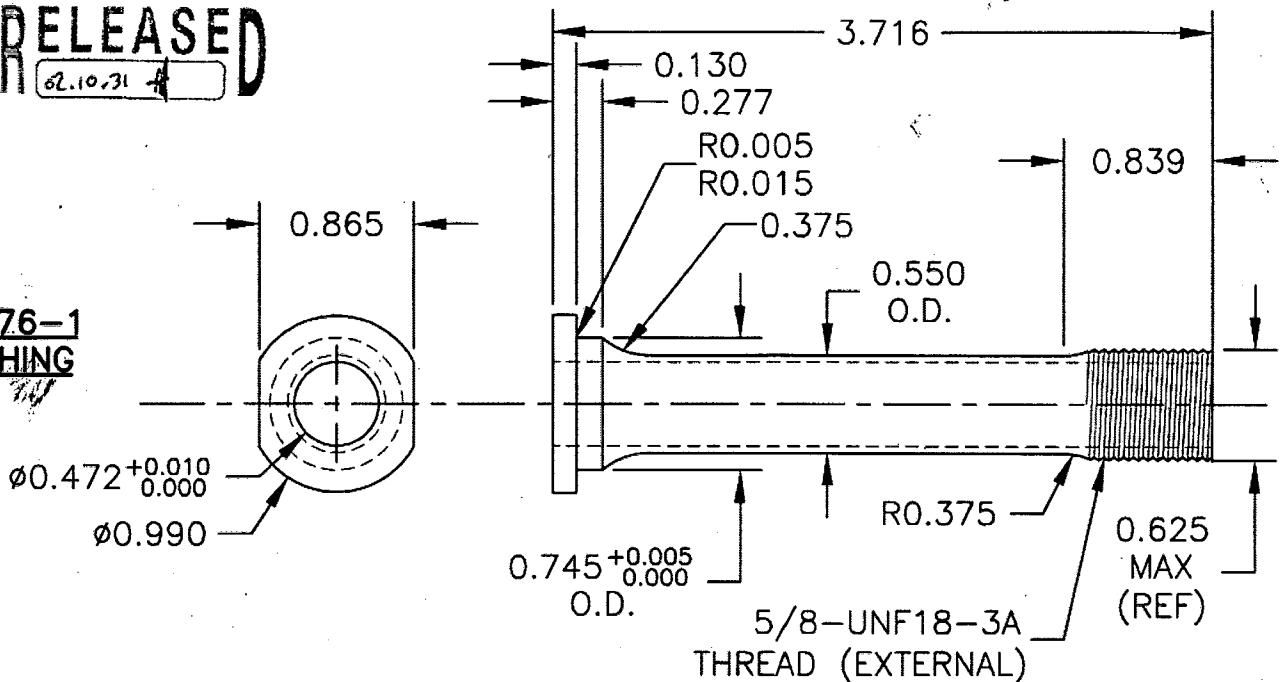
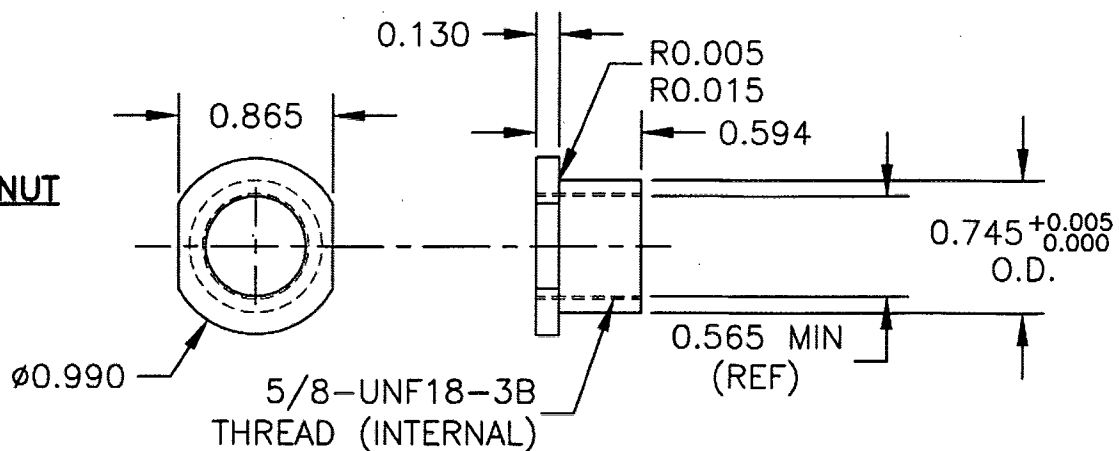
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

RELEASED
02.10.31**D3176-1
BUSHING****D3176-3 NUT****D3176-1/-3**

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
- 2) THREADS PER MIL-S-7742
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) FINISH: NONE
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) D3176-1/-3 ARE MATING PARTS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTED 44896

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